

Date: Wednesday, 12/5/2007 1:00:19 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOAT SKIDTUBE	
Job Number	: 35745		Part Number	: D412742013	
Estimate Number	: 10366		Drawing Number	: N/A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/5/2007 S.O. No. : N/A		Drawing Revision	: N/A	
Prsh Rev.	: NO		Material	:	
First Issue	: N/A		Due Date	: 12/30/2007 Qty: 1 Um: Each	
Previous Run	: 35744				
Written By					
Checked & Approved By					
Comment	: Est Rev: A 05.10.13 New Issue KJ/JLM				
	Est Rev:B 06-06-08 As per DS19336 JLM				
	Est RevC 07-12-03 ECN 1072 DD verified by:JLM				



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL 08/01/05	KS 07.12.06
2.0	35745A	FLOAT SKID ASSEMBLY	
3.0	PACKAGING 1	PACKAGING RESOURCE #1 1-8/01/04	0
4.0	D2571	Saddle, Fwd, Out B34367	18/07/20
5.0	D2572	Saddle, Fwd, In	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Seq. #:	Machine Or Operation:	Description :
6.0	D2573	Saddle, Aft, Out
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
1 D2573	Saddle Aft Outside	B34814
		AS 07/12/20 (X)
7.0	D2574	Saddle, Aft, In
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
1 D2574	Saddle Aft Outside	34840
		AS 07/12/20 (X)
8.0	D2876	Saddle Spacer
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
2 D2876	Saddle Spacer	Z9789
		AS 07/12/20 (X)
9.0	D2877	Saddle Spacer
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
2 D2877	Saddle Spacer	32104
		AS 07/12/20 (X)
10.0	D34031	Bushing
Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
16 D3403-1	Bushing	B35634
		AS 07/12/20 (X)
11.0	D2747	Set Screw
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
4 D2747	Bolt	B33470
		AS 07/12/20 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number:	
Seq. #:	Machine Or Operation:
12.0	D35331 Set Screw
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	AS 07/12/20 (X)
Set Screw	B28093
13.0	AN4C6A Bolt
Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)	AS 07/12/20 (X)
Pick:	
Qty Part Number	Description
16 AN4C6A	Bolt
	M105793
14.0	AN4C52A BOLT
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)	AS 07/12/20 (X)
Pick:	
Qty Part Number	Description
8 AN4C52A	Bolt
	M19512
15.0	AN6C12A BOLT
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)	AS 07/12/20 (X)
Pick:	
Qty Part Number	Description
8 AN6C12A	Bolt
	M104289
16.0	D36723 PHENOLIC WASHER
Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)	AS 07/12/20 (X)
PHENOLIC WASHER	B34471
17.0	AN960C416L WASHER
Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)	AS 07/12/20 (X)
WASHER	M105793
18.0	D36729 PHENOLIC WASHER
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)	AS 07/12/20 (X)
PHENOLIC WASHER	B35523

W/O:		WORK ORDER CHANGES					
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Job Number: 35745	Part Number: D412742013		
Job Number:			
Seq. #:	Machine Or Operation:		
19.0	AN960C616L	WASHER	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) WASHER	M18918	KS 07/12/20	(X)
20.0	D367211	PHENOLIC WASHER	
Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) PHENOLIC WASHER	B35524	AS 07/12/20	(X)
21.0	MS210434	Nut	
Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s) Nut	M106421	KS 07/12/20	(X)
22.0	AN4C7A	Bolt	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Bolt Batch: M101427		AS 07/12/20	(X)
23.0	D34033	Bushing	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch	35635	AS 07/12/20	(X)
24.0	D3405041	Lug Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch	357779	AS 07/12/20	(X)
25.0	D3405043	Lug Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch	B34841	AS 07/12/20	(X)

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT SKIDTUBE
Job Number: 35745		Part Number: D412742013
Job Number:		
Seq. #:	Machine Or Operation:	Description :
26.0	AN4C46A	BOLT
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
4 AN4C46A	Bolt	M19529
		AS 07/12/20 (X)
27.0	MS210434	Nut
Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Pick: 29.000		
Qty Part Number	Description	Batch
29 MS21043-4Nut		M166421
		AS 07/12/20 (X)
28.0	D3407041	Tow Ring
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
1 D3407-041	TOW RING	B35780
		AS 07/12/20 (X)
29.0	D34173	Washer
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
2 D3417-3	WASHER	B33519
		AS 07/12/20 (X)
30.0	D34561	washer
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty Part Number	Description	Batch
1 D3456-1	WASHER	B33276
		PC8/01/17 (1)
31.0	AN3C37A	BOLT
Comment: Qty.: 1.0000 EACH(s)/Unit Total : 1.0000 EACH(s)		
BOLT		
M106169		AS 07/12/20 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 35745		Part Number: D412742013
Job Number:		
Seq. #:	Machine Or Operation:	Description :
32.0	AN3C40A	BOLT
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	M106169	AS 07/12/20 (X)
BOLT		
33.0	AN3C41A	BOLT
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	M105858	AS 07/12/20 (X)
BOLT		
34.0	AN3C42A	BOLT
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	M106169	AS 07/12/20 (X)
BOLT		
35.0	AN3C43A	BOLT
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	M106176	AS 07/12/20
BOLT		
36.0	AN3C46A	BOLT
Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)	M106169	AS 07/12/20 (X)
BOLT		
37.0	AN960C10L	washer
Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)	M106552	AS 07/12/20 (X)
washer		
38.0	MS210433	Nut
Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)	M105792	AS 07/12/20 (X)
Nut		
39.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
Comment: INSPECT 100% KITS FOR COMPLETENESS		AS 08/01/15 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT SKIDTUBE
Job Number: 35745		Part Number: D412742013
Job Number:		
Seq. #:	Machine Or Operation:	Description :
40.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-742013 Location: <u>12</u> <u>08/01/14</u> <u>C</u>		
41.0	QC21 	FINAL INSPECTION/W/O RELEASE  <u>08/01/16</u>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		
<p><i>mu 2008/1/16</i></p> <p>POSITIVE RECALL EFFECTIVE <u>07-12-14</u> AUTH <u>1</u> RELEASED <u>07-12-14</u> DATE <u>1</u></p>		

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Wednesday, 12/5/2007 1:00:36 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	FLOAT SKID ASSEMBLY
Job Number	35745A		
Estimate Number	10756		
P.O. Number	N/A	Part Number	D412742043
This Issue	12/5/2007	S.O. No.	N/A
Prsh Rev.	NC	Drawing Number	D3391 REV G
First Issue	N/A	Project Number	N/A
Previous Run	35744A	Drawing Revision	G
Written By		Material	N/A
Checked & Approved By	<u>12/07/12/05</u>	Due Date	12/30/2007
Comment	Est Rev A 05.10.13 New Issue Est Rev B 06.02.13 ECN 773 dwg @ rev.D Est Rev:C 07-05-28 As per Rev F Est Rev:D 07-12-04 ECN 1072 by:JLM		
	KJ/JLM	Qty:	1
	EC	Um:	Each
	JLM		
	DD verified		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		Comment: DOCUMENT CONTROL If D412-742-043 is a W/O on its own, Photocopy bluefile and create labels per PPP D412-742-043 CHG003

2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1		
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1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M105005

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment, using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M105585Expiry date: 08/07

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M104251A/R Sikaflex-241/-291 M105585Expiry date: 08/07

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 35745A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0 D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-023 Mid Tube Assembly

B33641

m/d

4.0 D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-025 Aft Tube Assembly

B35774

m/d

5.0 D35641

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B33798

m/d

6.0 D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch:

B35788

m/d

7.0 D35643

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B33764

m/d

8.0 D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B34806

m/d

9.0 D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B34354

m/d 07/12/18

(1X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/16
 QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 35745A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 AN3C4A BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch:

M106431

m/h

11.0 AN3C6A BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch:

M105057

m/h

12.0 AN3C7A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch:

M105906

m/h

13.0 AN960C10L washer



M106574 *min 2008/1/16*

#(1x)

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch:

M106575

07/12/18 m/h

14.0 QC5 INSPECT WORK TO CURRENT STEP



07/12/19 (1)

Comment: INSPECT WORK TO CURRENT STEP

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

PPD 35745 *L. Taylor O*

16.0 QC21 FINAL INSPECTION/W/O RELEASE



08/01/16 (1)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



min 2008/1/16

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

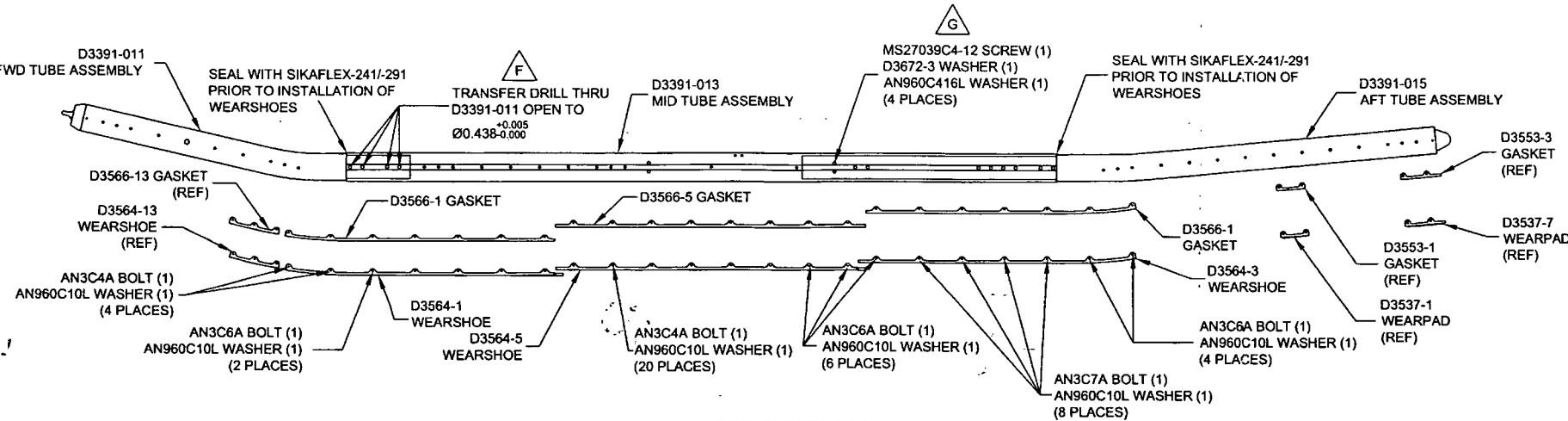
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

1



RELEASED
27-11-06 MPA

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C8A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

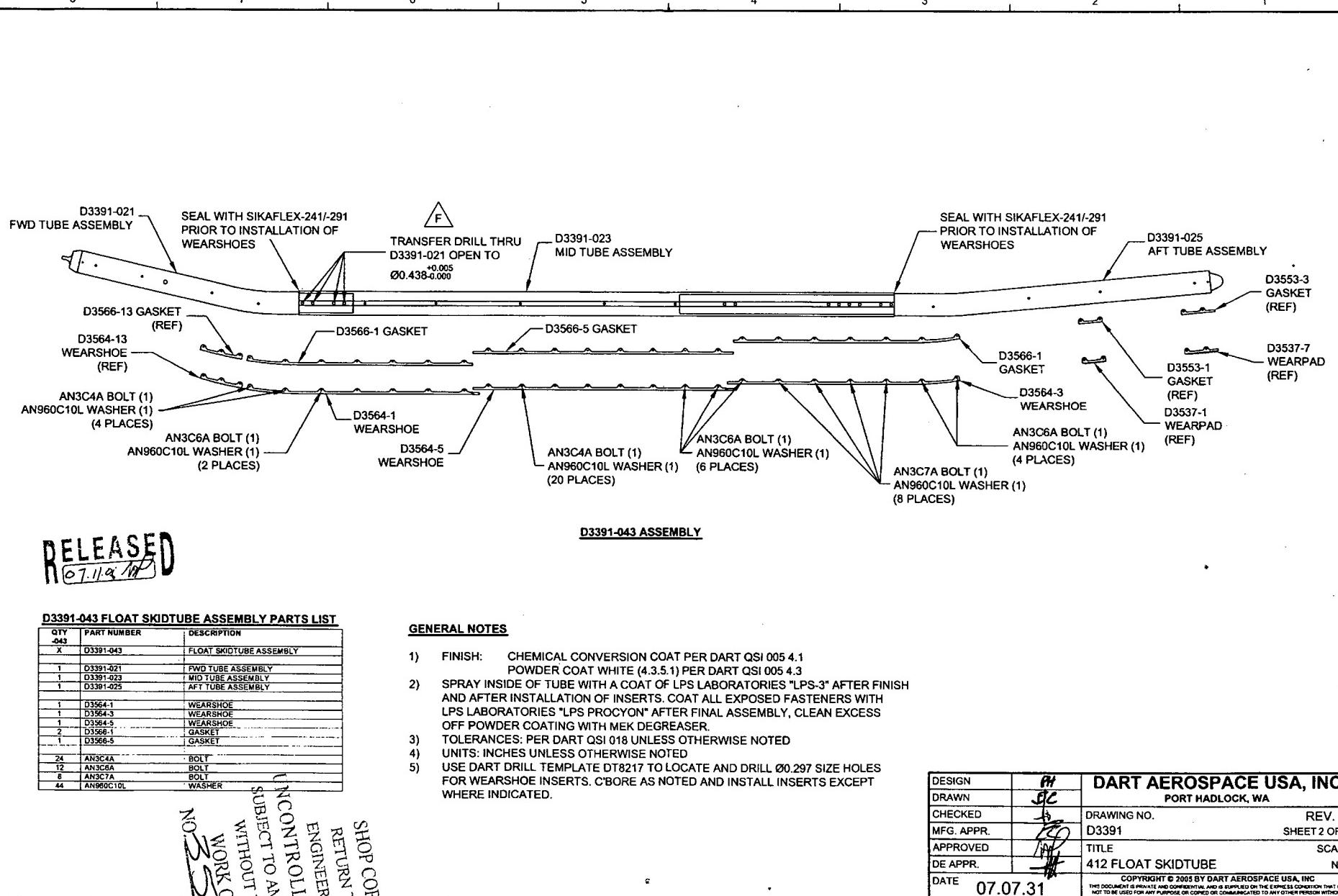
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) USED DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT

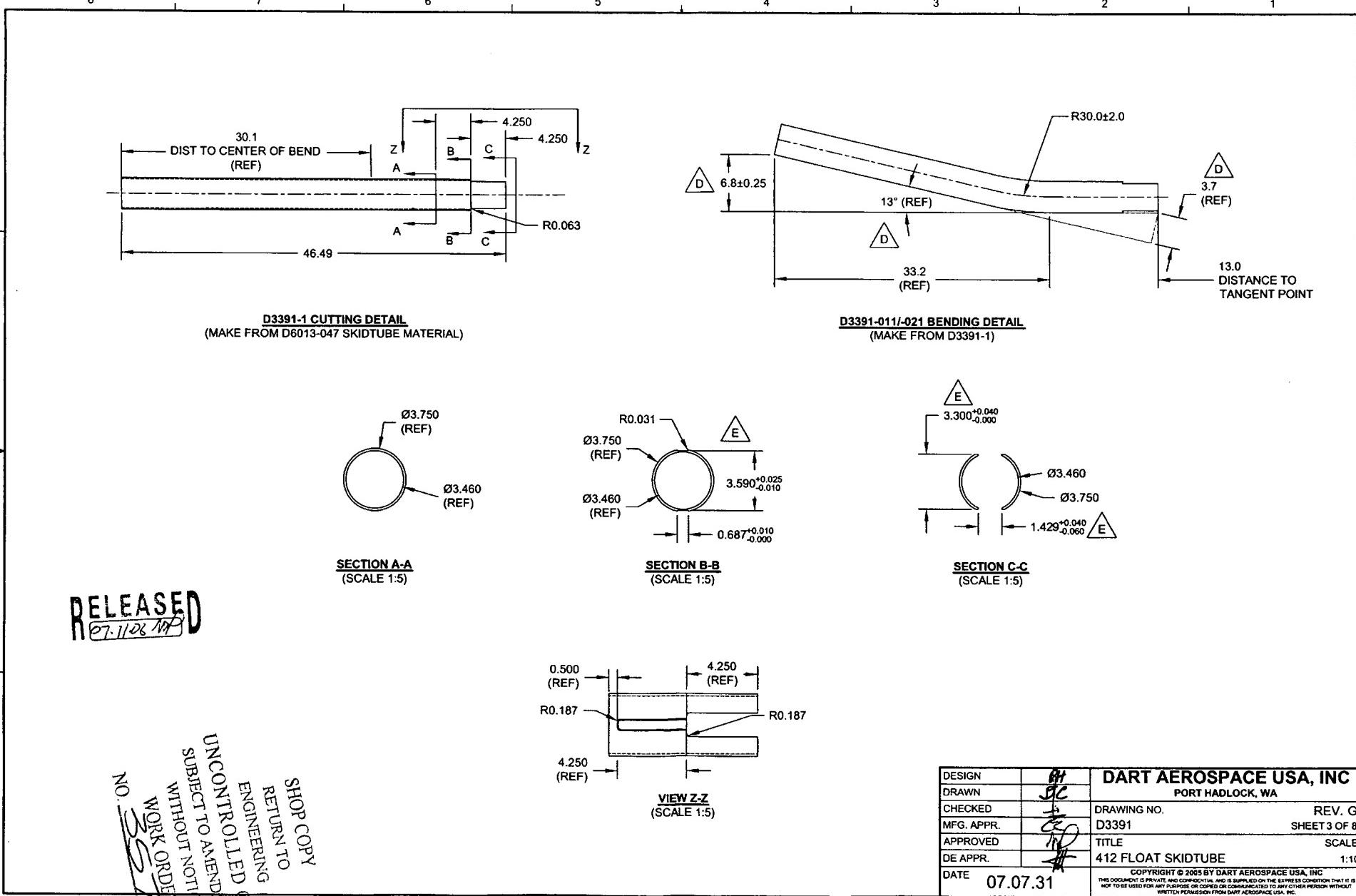
4) UNITS, INCHES UNLESS OTHERWISE SPECIFIED
5) USED PART DRILL TEMPLATE
FOR WEARSHOE INSERTS.
WHERE INDICATED
6) TROULED COPY
TROULED COPY
7) ENDMENT
TO A. ENDMENT
WHOUT NOTICE
WORK ORDER

G	REPLACE NAS INSERTS W/AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY		DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FW3 SADDLE HOLE -011-021		PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE		PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE		PH	06.01.23
C	LENGTHEN AFT EXTENSION		PH	05.09.27
B	DRAWING UPDATES		PH	05.06.10
A	NEW ISSUE		PH	05.02.07
REV.	DESCRIPTION		BY	DATE
DESIGN	AH		DART AEROSPACE USA, INC	
DRAWN	SJC		PORT HADLOCK, WA	
CHECKED	b		DRAWING NO.	REV. G
MFG. APPR.	bz		D3391	SHEET 1 OF 8
APPROVED	JW		TITLE	SCALE
DE APPR.	[Signature]		412 FLOAT SKIDTUBE	NTS
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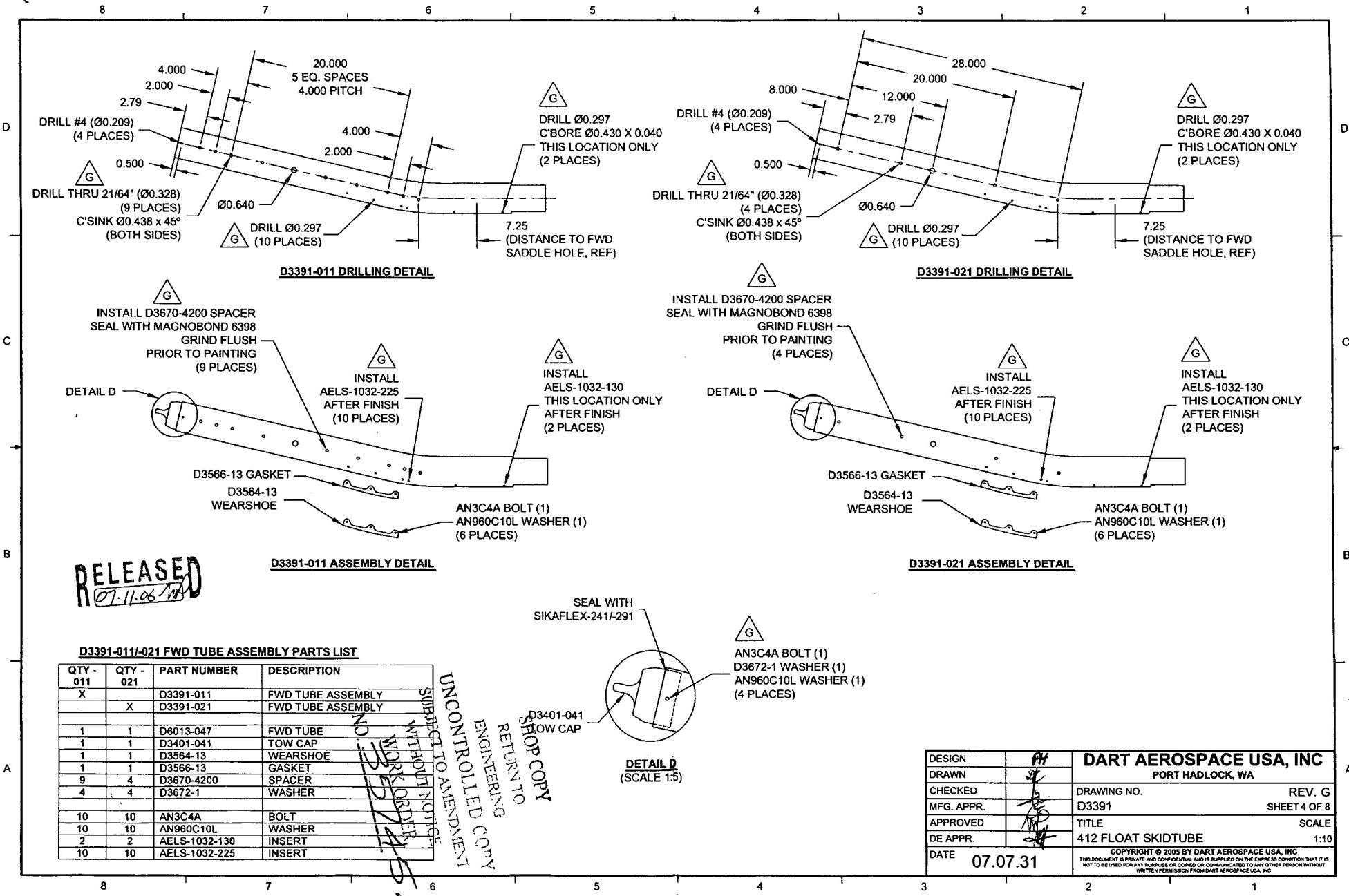
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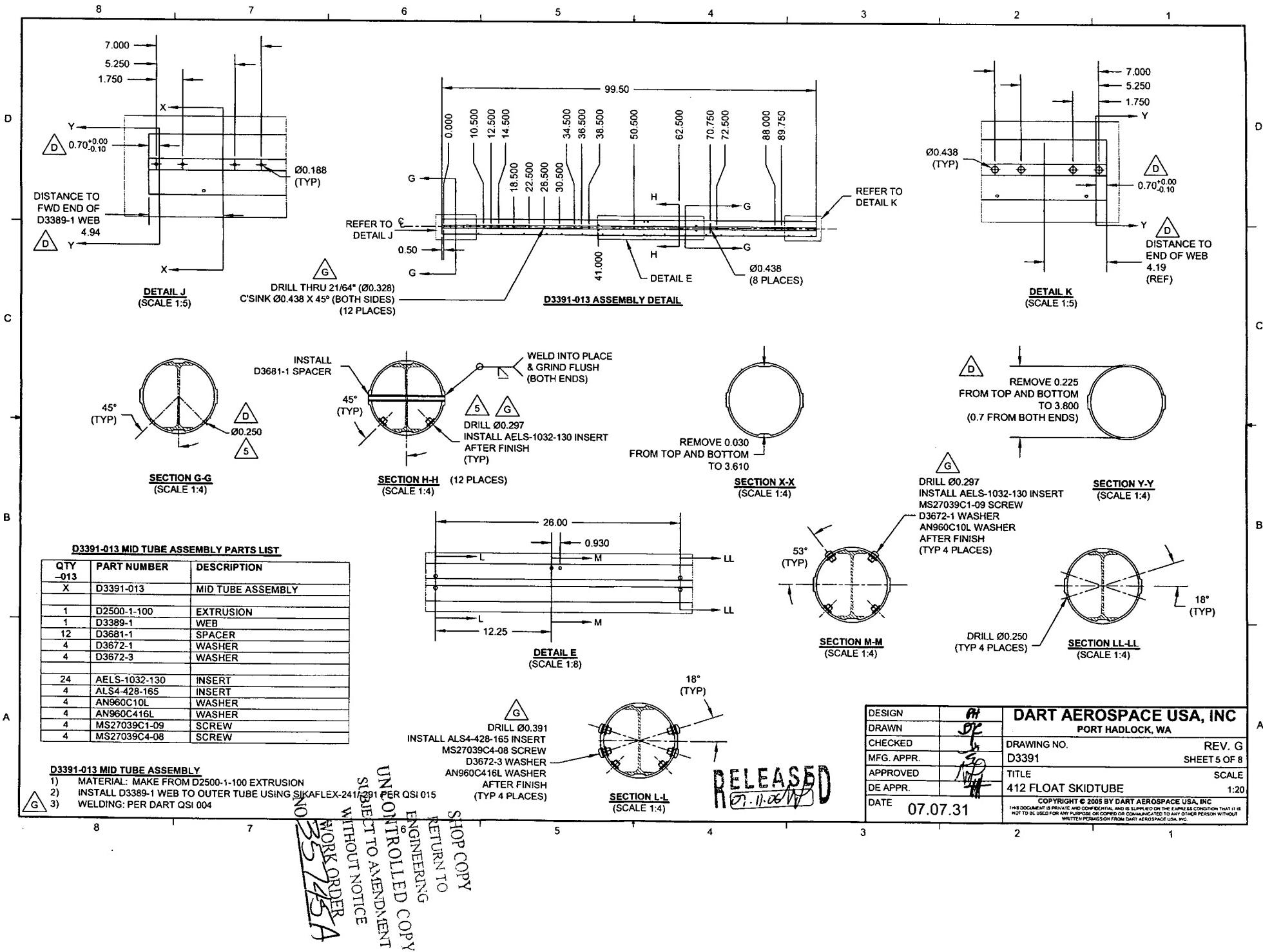


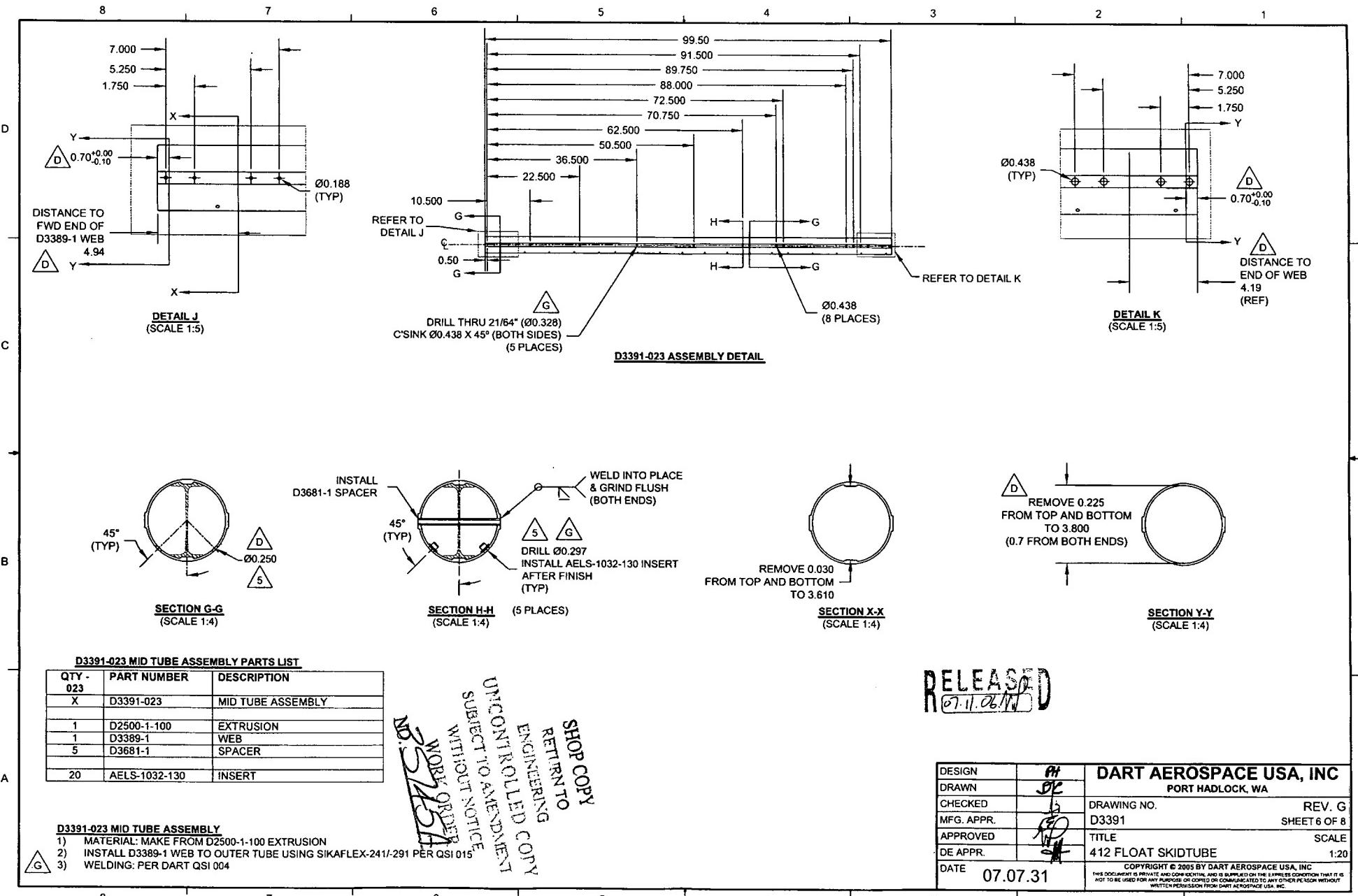
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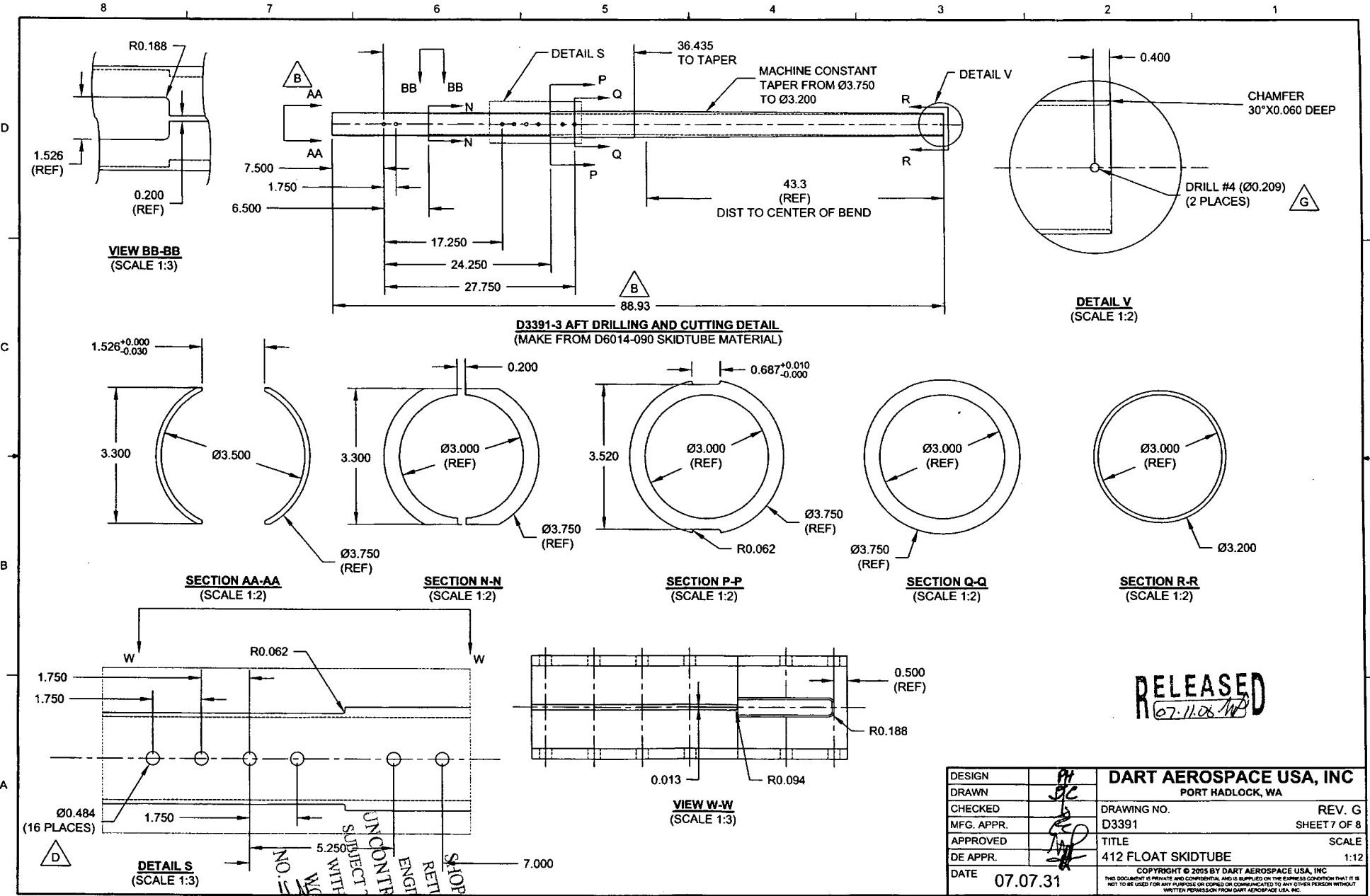


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